

206-181-173/16Y

Work Order ID 85043

85043

May-31-12 3:40:01 PM

Item ID: D3824-3KGY

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Hat Bin-Grey

Stop ***NS2***

Start Date: 31/05/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 14/06/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/01 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr Revision Nbr

D3824 Rev C

100 0.00

100

HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

B 12/06/19

105 0.00

105

HandThermo

Dry Material

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 KYDEX

Temp: 140

Time IN: 4:30

Time OUT: 7:00

B 12/06/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110

0.00

110

Thermoform

Memo

0.00

Thermoforming Machine

1-Machine Set-Up
2-Pre-heat Tool to required temp.
3-Thermoform as per Dwg and Folio #FTA034 using tool DT9448
Dwg Rev: S
Folio Rev: B

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

Visually inspect part for proper formation and texture

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

B 12/06/19

B 12/06/19

DL
12/06/19

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Work Order ID 85043

May-31-12 3:40:01 PM

85043

Page 4

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Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Hat Bin-Grey

Start Date: 31/05/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 14/06/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

170

Identify as per dwg & Stock Location: _____

0.00

170

Packaging

Memo

PP86186

0.00

Packaging

6/4/12/22 *(7)*

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

12/6/28 *JD*

MW 12/06/22

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

May-31-12 3:40:05 PM

Page 1

Work Order ID: 85043

85043

Parent Item: D3824-3KGY

D3824-3KGY

Parent Item Name: Hat Bin-Grey

Start Date: 31/05/2012

Required Date: 14/06/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP RevA: New issue DD verified by:EC
Add Step 105 Dry Material 10/04/21 DL

Ipp Rev. B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.125-P3- 52068		Purchased		No		100	sf	519.3962	11.41	11.41571			

MKYD6185S 125-P3-52068

Kydex steel grey

**

Location

therm

111807

111875

Loc Qty

519.39616

156.74858

362.64758

Loc Code

11.41571

Sh
12/06/20

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order:	85043
Description: Hat Bin		Part Number:	D3824-3KIV/KGY
Inspection Dwg: D3824	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: BB Date: 12/06/20

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.43	+0.05/-0.00	.473	✓			
48.5	Ref	48.4	✓			
34.1	Ref	34.1	✓			
41.6	Ref	41.62	✓			
3.5	Ref	3.5	✓			
0.055	Min	.104	✓			

Measured by: BB Date: 12/06/20

Audited by: DK Date: 12/06/20

Prototype Approval: N/A Date: N/A

Rev	Date	Change	Revised by	Approved
A	09.06.26	New Issue	KJ <u>BB</u>	<u>BB</u>

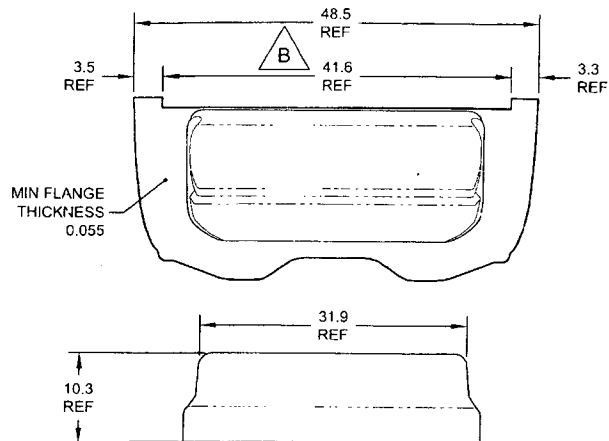
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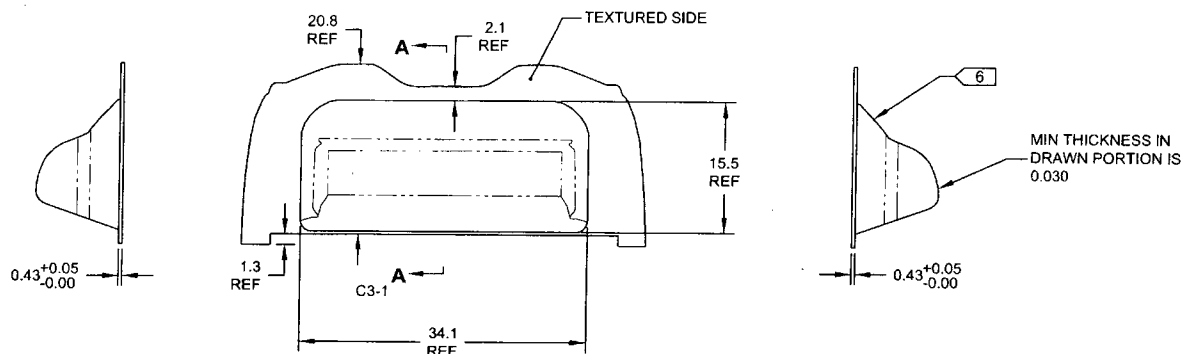


SECTION A-A
SCALE 2X

B6-1

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 85043 MLS
12/06/01

RELEASED
8/15/02



D3824-1 HAT BIN
(BELL 206 A/B)

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 5.6 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9405 PER DART QSI 022. TRIM PER MOLD



PART NUMBER	DESCRIPTION
D3824-1KIV	KYDEX 6185, 0.125 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3824-1KGY	KYDEX 6185, 0.125 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

C	ADD STEEL GRAY COLOUR OPTION, ADD IVORY P/N'S D3824-1KIV, D3824-3KIV AND ADD STEEL GRAY P/N'S D3824-1KGY, D3824-3KGY (ZN A5-1, A5-2)	PH	09.05.05
B	0.125 THICK WAS 0.080 (ZN A7-1, A7-2) REASON: TO IMPROVE DURABILITY: MODIFY WIDTH TO ALLOW FOR BETTER FIT WITH A/C (ZN D6-1, D6-2)	PH	09.02.19
A	NEW ISSUE	PH	08.10.01
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.05.05		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3824 REV. C SHEET 1 OF 2 TITLE HAT BIN (BELL 206 A/B) SCALE NTS COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

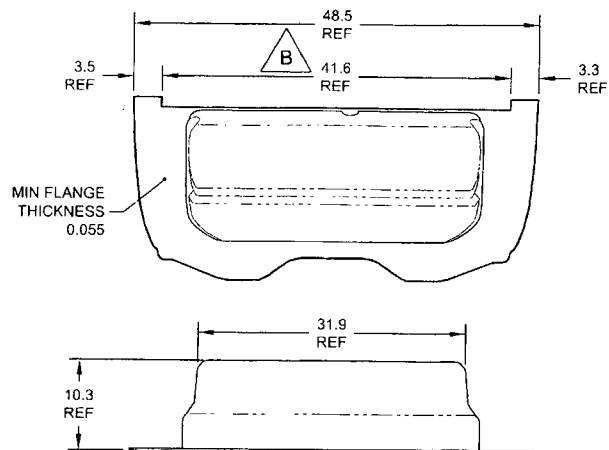
W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

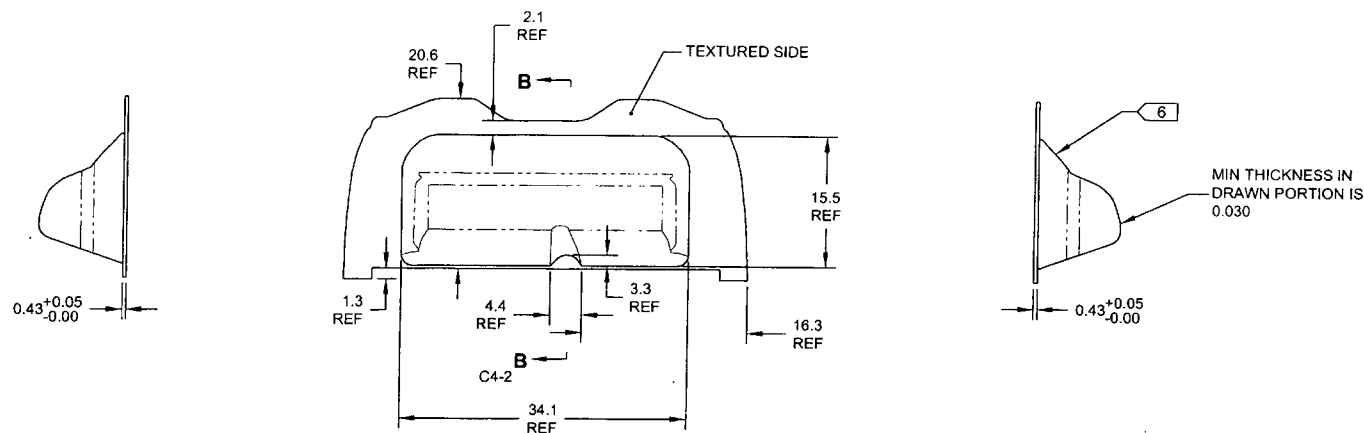
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NOTE: Date & initial all entries



SECTION B-B
SCALE 2X

25043



D3824-3 HAT BIN
(BELL 206 A/B, LITTER KIT COMPATIBLE)

RELEASED
29/05/12

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 5.6 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9448 PER DART QSI 022. TRIM PER MOLD



PART NUMBER	DESCRIPTION
D3824-3KIV	KYDEX 6185, 0.125 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3824-3KGY	KYDEX 6185, 0.125 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. C
MFG. APPR.	PH	D3824	SHEET 2 OF 2
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	HAT BIN (BELL 206 A/B)	NTS
DATE	09.05.05	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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